

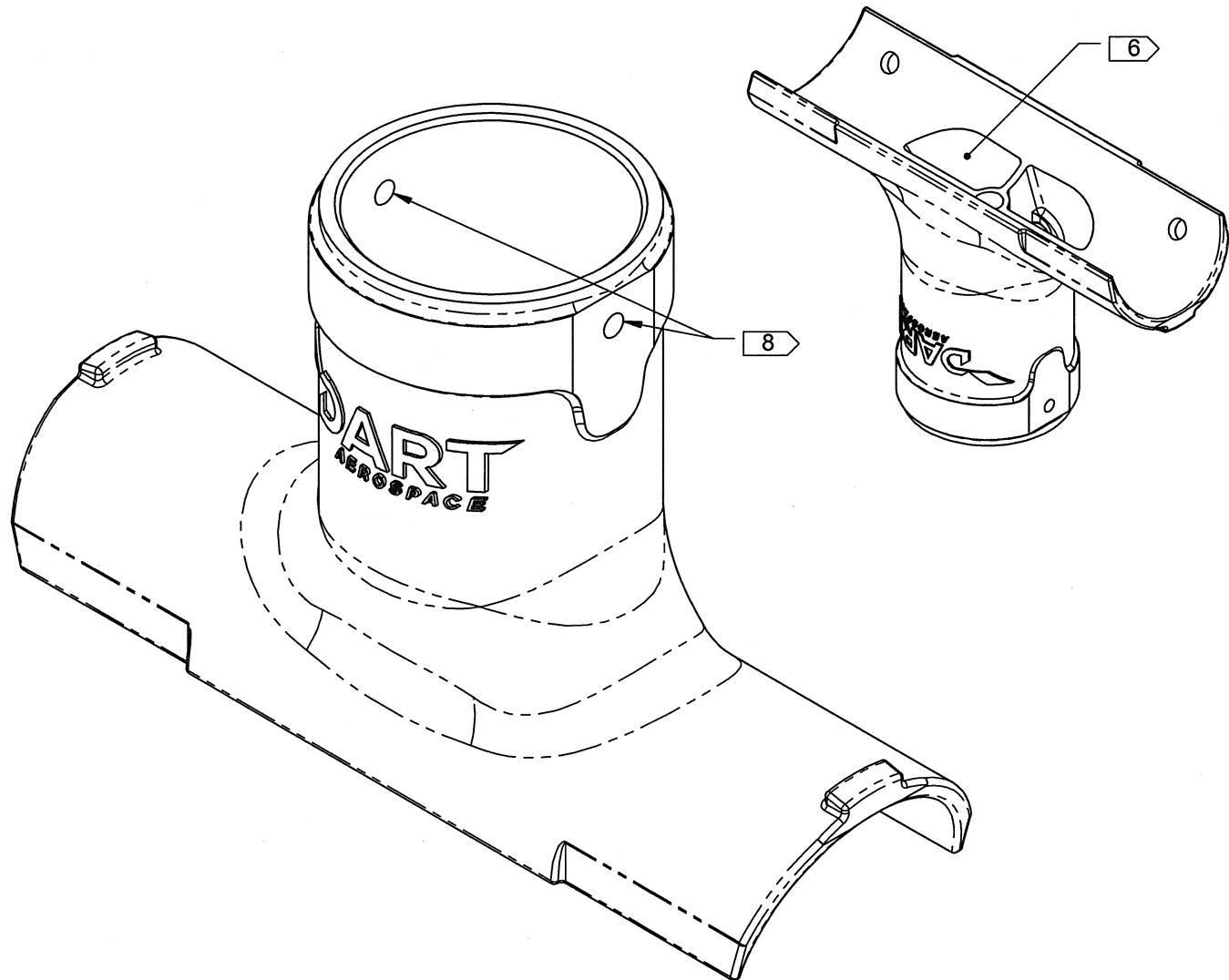
8 7 6 5 4 3 2 1

D

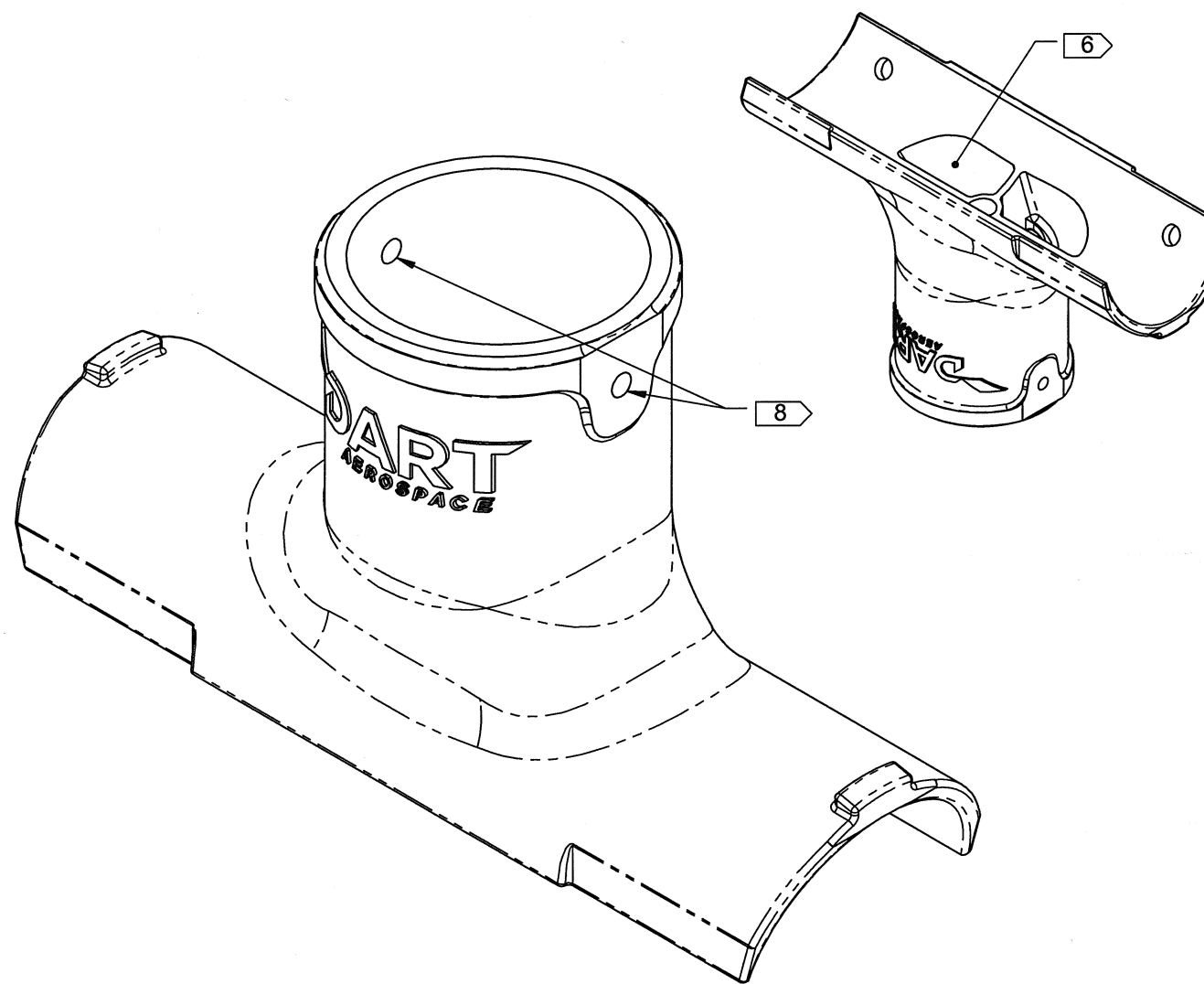
C

B

A



D5415-1 MID HEIGHT SADDLE



D5415-3 STANDARD HEIGHT SADDLE

RELEASED
2019 FEB 15
ECN 19-593

- NOTES:
- 1) MATERIAL: MAKE FROM D5415-1C/-3C
 - 2) FINISH: PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2.1.3.3 (FLOAT SKIDTUBE PRIMER)
PAINT OUTSIDE PER DART QSI 005 4.2.2.4 (FLOAT SKIDTUBE PAINT)
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: DART P/N "D5415-1" OR "D5415-3" AND S/N PER QSI 044 6.4 (VIBRATING STYLUS) PRIOR TO FINISH
DART P/N "D5415-1" OR "D5415-3" AND S/N PER QSI 044 6.1 (PAINT MARKER) AFTER FINISH
LOCATE APPROX AS SHOWN
 - 7) WEIGHT: D5415-1 is 3.72 LBS, D5415-3 is 3.42 LBS
 - 8) MASK HOLES PRIOR TO PRIME AND PAINT

APPROVED

D	ADDED 7050 ALUMINUM PLATE AS ALTERNATE MATERIAL FOR -1C/-3C	ZF	19.01.28
C	REDESIGNED SADDLE ALIGNMENT METHOD, INCORPORATED SADDLE RADIUS WASHER (D5562-1) INTO CASTING. SHEET 1: ADDED NOTE 8. SHEET 4: 3.565 WAS 3.550, 2.715 WAS 2.700.	MW	18.08.29
B	ADDED -3 STANDARD HEIGHT SADDLE, REVISED NOTES, REMOVED CAST P/N FROM -1 SADDLE, Ø0.323 HOLE WAS Ø0.325, SECTION B-B AND D-D ±0.005 WAS ±0.010	ML	17.09.05
A	NEW ISSUE	ML	16.05.17
REV.	DESCRIPTION	BY	DATE
DESIGN	ML	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	ZF		
CHECKED	MW	DRAWING NO.	REV. D
MFG. APPR.	RQ	D5415	SHEET 1 OF 4
APPROVED	NO	TITLE	SCALE
DE APPR.	CP	SADDLE	NTS
DATE	19.01.28	COPYRIGHT © 2016 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

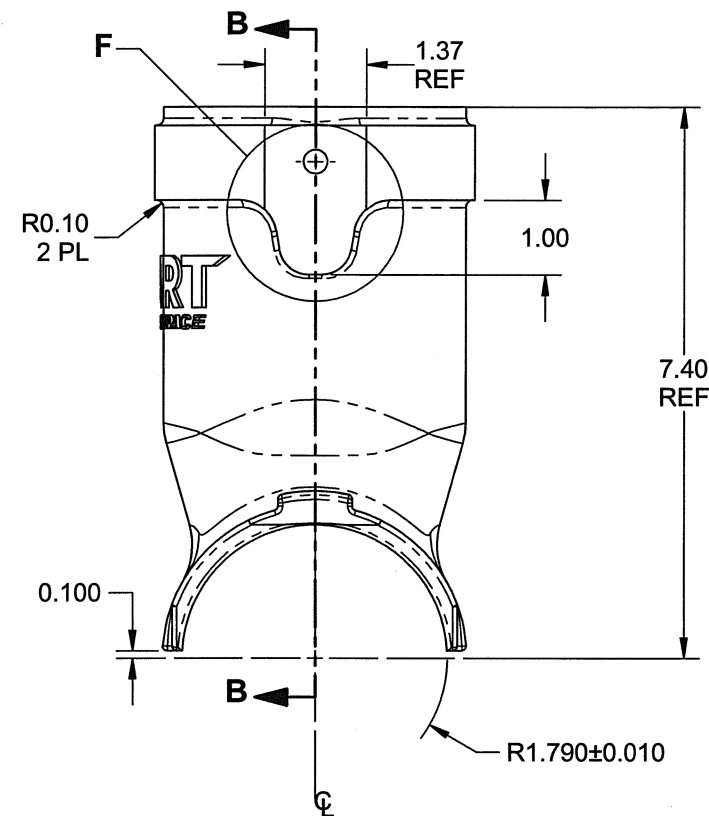
D

C

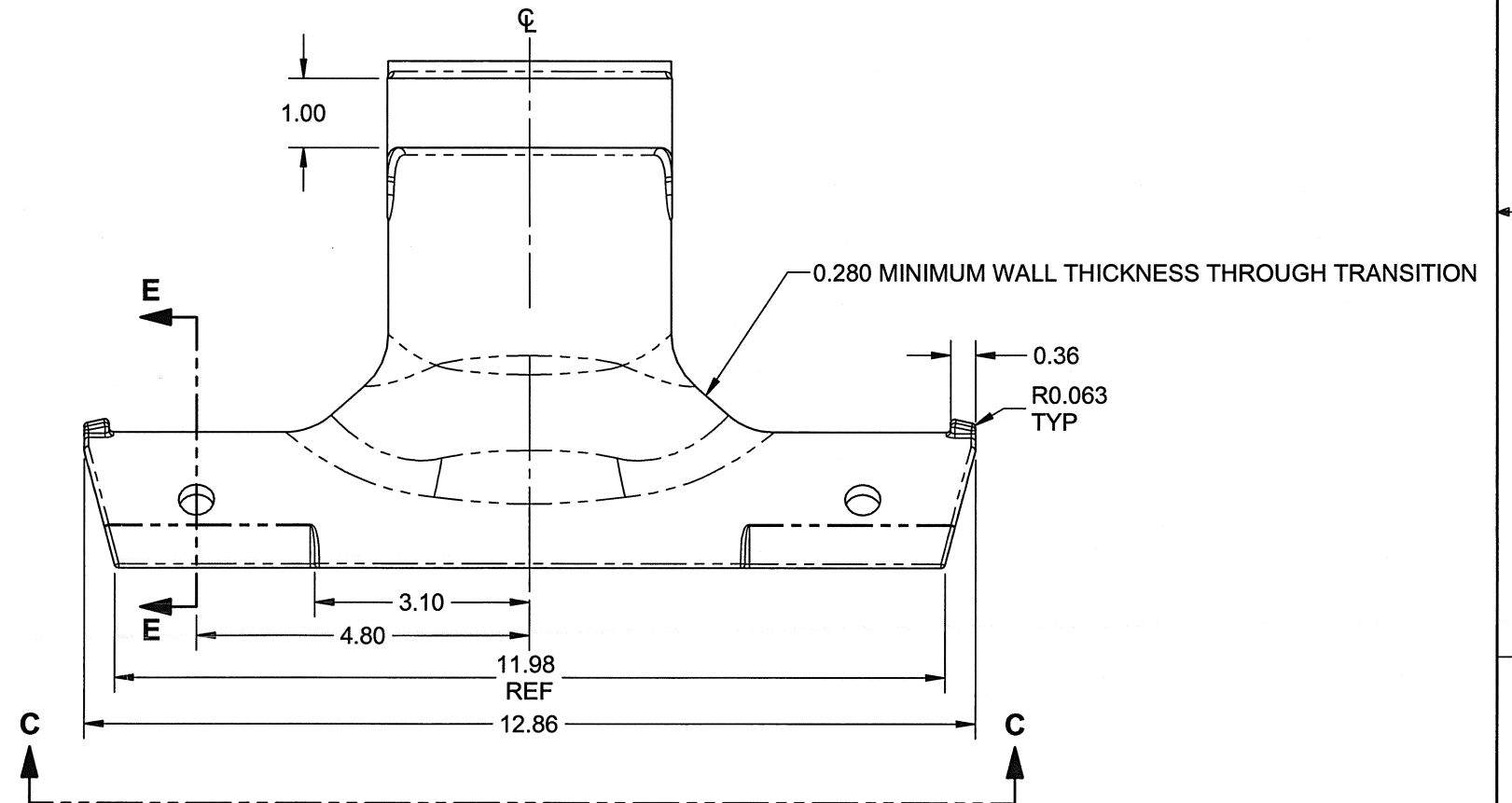
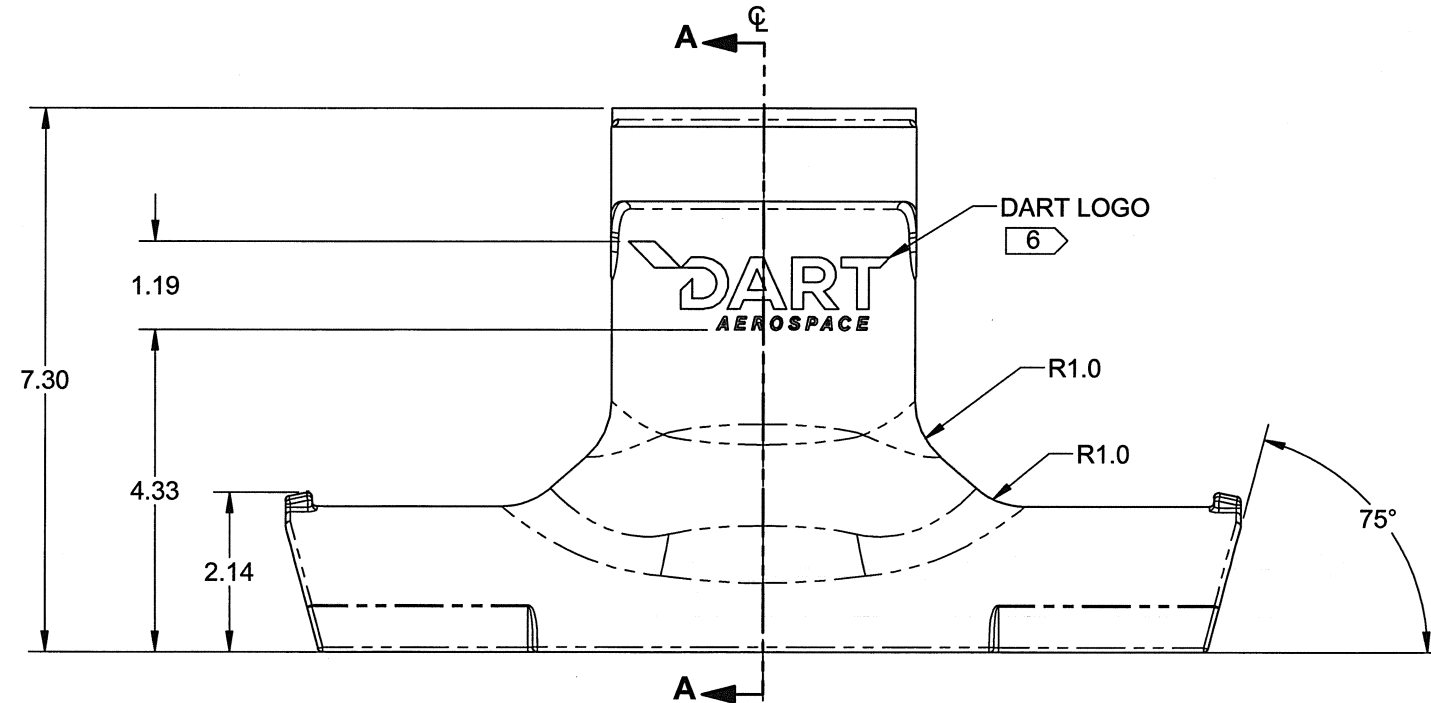
B

A

8 7 6 5 4 3 2 1



D5415-1C MID HEIGHT SADDLE



NOTES:

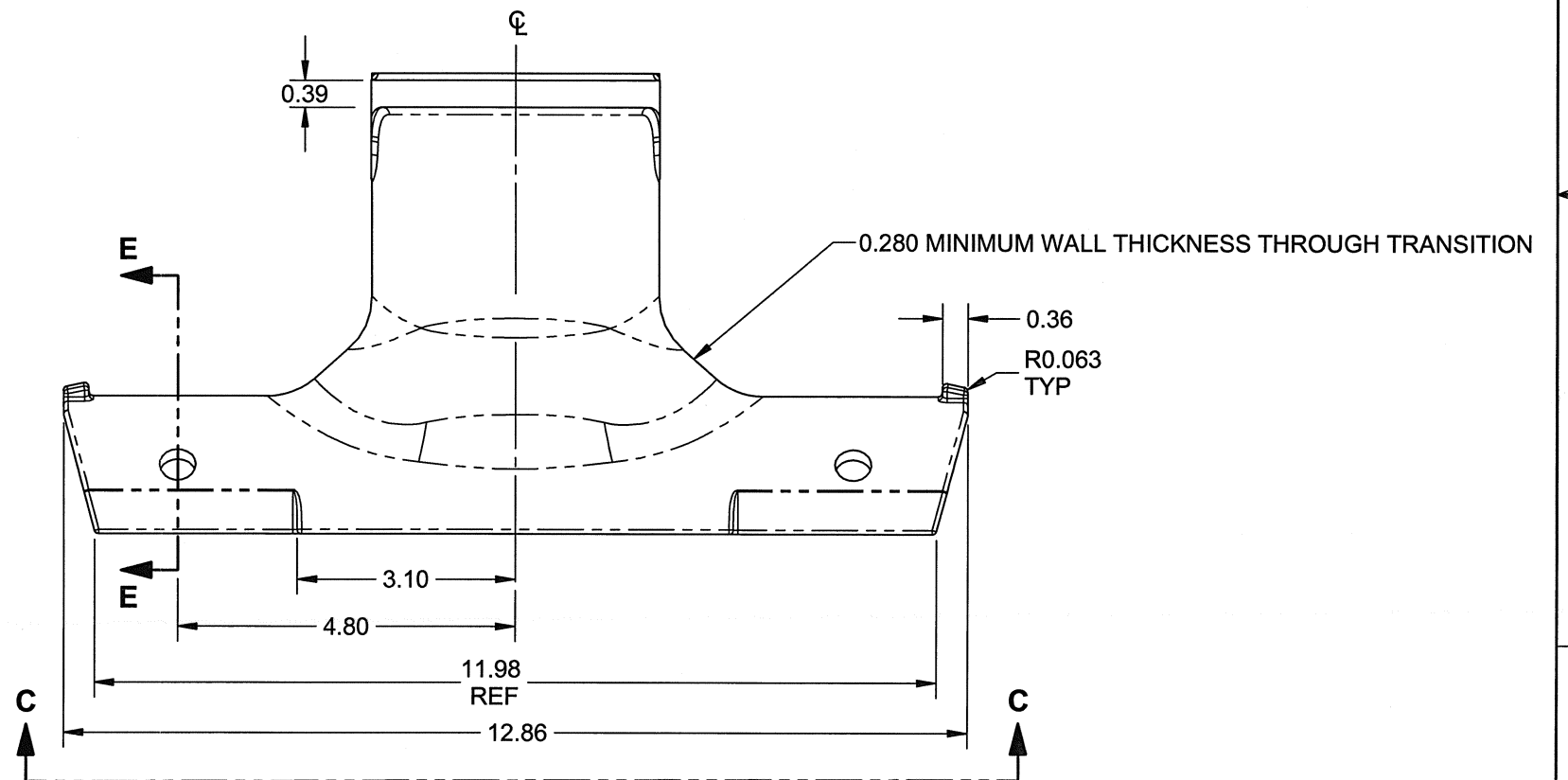
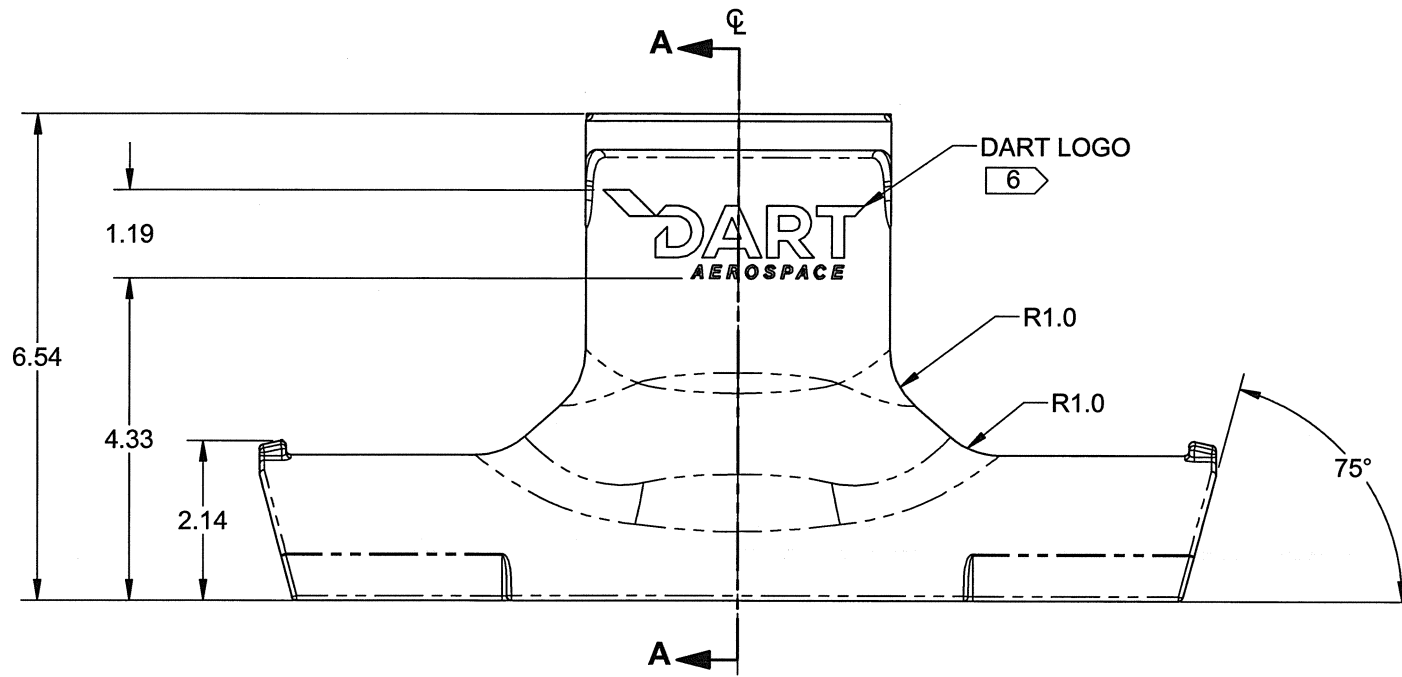
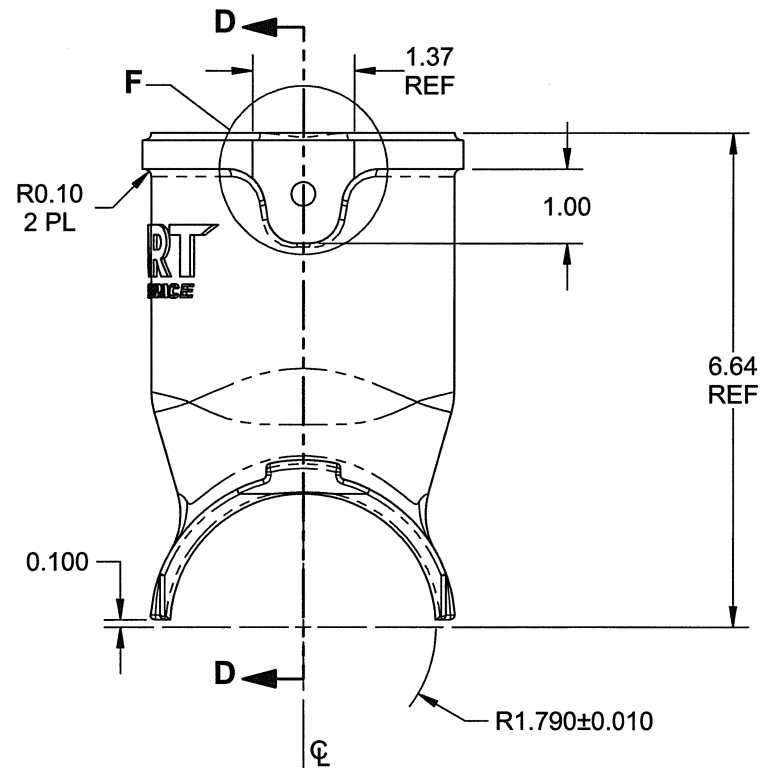
- 1) MATERIAL: CAST FROM F357.0 PER AMS 4289 AND HEAT TREAT TO T6 CONDITION
PROPERTIES TO BE VERIFIED BY SUB-SIZED SEPARATELY CAST TEST BARS
OR
MACHINE FROM 7050-T7451 OR -T7651 ALUMINUM PLATE
PER AMS 4050 (-T7451) OR AMS 4201 (-T7651)
REF DART SPEC M7050P
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: DART LOGO RAISED ABOVE SURFACE AS SHOWN, MAX 0.015 TOOL RAD
- 7) WEIGHT: N/A
- 8) COSMETIC WELD REPAIR ALLOWED IF CAST FROM F357.0,
REPAIR PER AMS 2694 PRIOR TO INSPECTION AND HEAT TREAT.
NO COSMETIC WELD REPAIR ALLOWED IF MACHINED FROM 7050 PLATE
- 9) MANDATORY INSPECTION IF CAST FROM F357.0:
EACH PART MUST PASS X-RAY CL. 1 GR. B PER AMS 2175
EACH PART MUST PASS FPI CL. 1 GR. B PER AMS 2175
NO X-RAY OR FPI REQUIRED IF MACHINED FROM 7050 PLATE
- 10) ALL NON DIMENSIONED FEATURES MUST MAINTAIN A TOLERANCE OF +/- 0.030 PER
CAD FILE D5415-1-REV_D.STP
- 11) ANY ADDITIONAL MATERIAL REQUIRED FOR POST-CASTING MACHINING IS
NOT SPECIFIED ON THIS DRAWING.

RELEASED

2019 FEB 15

APPROVED

DESIGN	ML	DART AEROSPACE LTD	
DRAWN	ZF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MW	DRAWING NO.	REV. D
MFG. APPR.	RQ	D5415	SHEET 2 OF 4
APPROVED	NO	TITLE	SCALE
DE APPR.	CP	SADDLE	NTS
DATE	19.01.28	<small>COPYRIGHT © 2016 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



D5415-3C STANDARD HEIGHT SADDLE

NOTES:

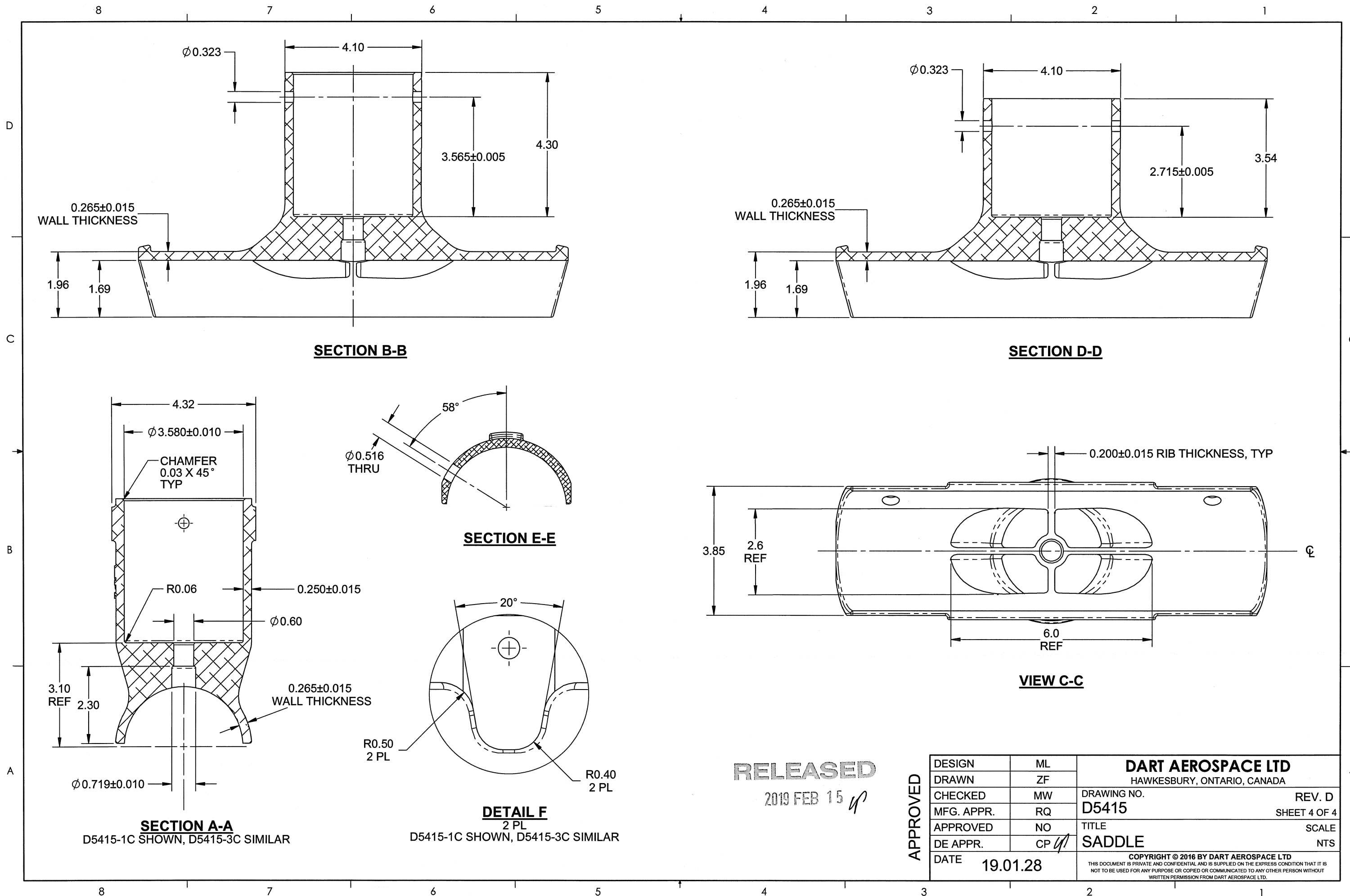
- 1) MATERIAL: CAST FROM F357.0 PER AMS 4289 AND HEAT TREAT TO T6 CONDITION
PROPERTIES TO BE VERIFIED BY SUB-SIZED SEPARATELY CAST TEST BARS
OR
MACHINE FROM 7050-T7451 OR -T7651 ALUMINUM PLATE
PER AMS 4050 (-T7451) OR AMS 4201 (-T7651)
REF DART SPEC M7050P
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: DART LOGO RAISED ABOVE SURFACE AS SHOWN, MAX 0.025 TOOL RAD
- 7) WEIGHT: N/A
- 8) COSMETIC WELD REPAIR ALLOWED IF CAST FROM F357.0,
REPAIR PER AMS 2694 PRIOR TO INSPECTION AND HEAT TREAT.
NO COSMETIC WELD REPAIR ALLOWED IF MACHINED FROM 7050 PLATE
- 9) MANDATORY INSPECTION IF CAST FROM F357.0:
EACH PART MUST PASS X-RAY CL. 1 GR. B PER AMS 2175
EACH PART MUST PASS FPI CL. 1 GR. B PER AMS 2175
NO X-RAY OR FPI REQUIRED IF MACHINED FROM 7050 PLATE
- 10) ALL NON DIMENSIONED FEATURES MUST MAINTAIN A TOLERANCE OF +/- 0.030 PER
CAD FILE D5415-3-REV D.STP
- 11) ANY ADDITIONAL MATERIAL REQUIRED FOR POST-CASTING MACHINING IS
NOT SPECIFIED ON THIS DRAWING.

RELEASED

2019 FEB 15

APPROVED

DESIGN	ML	DART AEROSPACE LTD	
DRAWN	ZF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MW	DRAWING NO.	REV. D
MFG. APPR.	RQ	D5415	SHEET 3 OF 4
APPROVED	NO	TITLE	SCALE
DE APPR.	CP	SADDLE	NTS
DATE	19.01.28	<small>COPYRIGHT © 2016 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



RELEASED
2019 FEB 15

APPROVED

DESIGN	ML	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	ZF		
CHECKED	MW	DRAWING NO.	REV. D
MFG. APPR.	RQ	D5415	SHEET 4 OF 4
APPROVED	NO	TITLE	SCALE
DE APPR.	CP	SADDLE	NTS
DATE	19.01.28	COPYRIGHT © 2016 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	